

**In the Claims:**

1. **(Currently Amended)** A method of extruding structural members comprising:(a)providing an alloy comprising consisting essentially of:

about 3.6 to about 4.2 wt % copper,  
 about 1.0 to about 1.6 wt % magnesium,  
 about 0.3 to about 0.8 wt. % manganese,  
 about 0.05 to about 0.25 wt. % zirconium,  
not more than about 0.08 wt.% iron,  
not more than about 0.06 wt.% silicon

the balance substantially aluminum, incidental elements, and impurities;

(b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;

(c) solution heat treating said extrusion; and  
 quenching said extrusion before making a structural member therefrom.

2. **(Currently Amended)**The method of claim 1 wherein the extruding extrusion billet temperature in step (b) is about 550° to about 650°F.

3. **(Currently Amended)** The method of claim 1 wherein the extrudingextrusion billet temperature in step (b) is about 600° to about 650°F.

4. **(Original)** The method of claim 1 which further includes:

(e) stretching said extrusion by at least about 1 %.

5. **(Previously Presented)** The method of claim 27 which further includes:

(e) stretching said extrusion between about 1 to about 10%.

6. **(Previously Presented)** The method of claim 27 which further includes:

(e) stretching said extrusion between about 1 to about 8%.

7. **(Previously Presented)** The method of claim 27 which further includes:

(e) stretching said extrusion between about 1 to about 3%.

8. **(Previously Presented)** The method of claim 27 which further includes:
  - (e) stretching said extrusion by at least about 1 %, said extrusion having less than about 50% by volume recrystallized after stretching.
  
9. **(Previously Presented)** The method of claim 27 which further includes in step (e):
  - (e) stretching said extrusion by at least about 1 %, said extrusion being substantially unrecrystallized.
  
10. **(Previously Presented)** The method of claim 27 which further includes in step (e):
  - (e) stretching said extrusion by at least about 1 %, said extrusion having a longitudinal yield strength of at least about 50 ksi and a longitudinal tensile ultimate strength of at least about 70 ksi.

#### **Claims 11-26 Cancelled**

27. **(Currently Amended)** A method of extruding structural members consisting essentially of:
  - (a) providing an alloy ~~comprising~~consisting essentially of:
    - about 3.6 to about 4.2 wt % copper,
    - about 1.0 to about 1.6 wt. % magnesium,
    - about 0.3 to about 0.8 wt % manganese,
    - about 0.05 to about 0.25 wt.% zirconium,
    - not more than about 0.08 wt.% iron,
    - not more than about 0.06 wt.% silicon,
    - the balance substantially aluminum, incidental elements, and impurities;
  - (b) extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;
  - (c) solution heat treating said extrusion;
  - (d) quenching said extrusion before making a structural member

therefrom; and

(e) stretching said extrusion by at least about 1 %.

28. **(Currently Amended)** A method of extruding structural members having a combination of high strength and toughness, said method comprising:

- (a) providing an alloy ~~comprising~~consisting essentially of:
  - about 3.6 to about 4.2 wt. % copper,
  - about 1.0 to about 1.6 wt. % magnesium,
  - about 0.3 to about 0.8 wt. % manganese,
  - about 0.05 to about 0.25 wt.% zirconium,
  - not more than about 0.08 wt.% iron,
  - not more than about 0.06 wt.% silicon,
  - the balance substantially aluminum, incidental elements, and impurities;
- (b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;
- (c) solution heat treating said extrusion; and
- (d) quenching said extrusion before making a structural member therefrom.